

Work Order ID 50735

July 21, 2009 12:43:24 PM

Page 1

Item ID: D2022-103

Accept

Revision ID: N/A

Item Name: Spacer

Start Date: 7/03/09

Start Qty: 20.00

Required Date: 7/06/09

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2022

Rev ...

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Note: .323 (P) Dia drill. 12-Turn Blank as per FolioFA2071 13-Tumble & deburr any sharp edges as per dwg

09-07-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

09-07-28 (23) ✓

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

09/07/27 (23) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50735

July 21, 2009 12:43:24 PM



Page 2

Item ID: D2022-103

Accept



Setup Start



Revision ID: N/A

Stop



Item Name: Spacer

Start Date: 7/03/09

Start Qty: 20.00



Cust Item ID:

Required Date: 7/06/09

Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

109

0.00



Packaging

Memo

0.00

Packaging

9/8/4

50 234

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

50812
H

u 9.08.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Status	Item ID	Rev	Name	Start Date	Quantity	PeJOMp Date	Secrap	ap	Quammeind	NEC	ICX	Sortme	Offset	an	Ty1	Per	Och	to	lore	Ce	Last	dd	Da
✓	M6061T6R0.750		6061-T6 Round B...	6/24/09	0.0300	f		100	0	0.0...					1	0	M...				6/3...	6/...	

Picklist Print

July 23, 2009 7:00:01 AM

Page 1

Work Order ID: 50735

Parent Item: D2022-103RevN/A

Parent Item Name: Spacer

Comments:

Start Date: 7/03/09

Required Date: 7/06/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No				f	22.9700	0.6000			
6061-T6 Round Bar .750"												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	22.97	
110791	2.97	
112041	20	



_____ 5'


_____ 09-07-28

DART AEROSPACE LTD		Work Order:	80133
Description: Spacer		Part Number:	D2022-103
Inspection Dwg: D2022 Rev: --		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

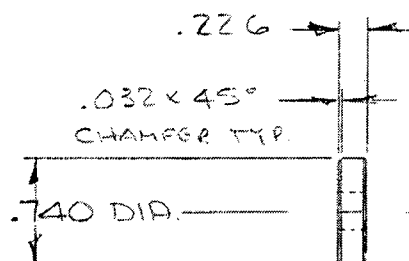
[illegible]

Measured by: 	Audited by: 	Prototype Approval: N/A
Date: 09.07.18	Date: 09.07.18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	

RELEASED
170114 BW

10,6735



D2022-101
D2022-103

DRILL 'F' (.257) DIA. IN -101
DRILL 'P' (.323) DIA IN -103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/E)



D2022

D2022-103	SPACER 5/16	ALUM 6061-T6	QQ-A-250/B
D2022-101	SPACER 1/4	ALUM 6061-T6	QQ-A-250/B

REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE SAME BASIS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523	QTY. REQUIRED	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED	BASIC CODE	APPROVAL	CONTRACT NO.	DART AERO ACCESSORIES INC				
	1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES: 12.1 3. READING SHARP EDGES 0.10 MAX 4. THREADS PER MIL - 2 - 7742 5. HOLES PER MIL AND 10987	1. TOLERANCES - AS X 030 2. ANGLES - 90 X 010 3. PARALLELISM - 0.0025 4. ECCENTRICITY - 0.005 MAX 5. SYMMETRY ABOUT - ALL MAT. CENTRE LINES 0.05	DRAWN: BRADLEY DATE: 10/15/81 DESIGN: BRADLEY STRESS: CHECKED: CLIENT:	DATE: 10/15/81 CLIENT:	TITLE: SPACERS CODE: D2022 SCALE: 1:1 SHT: 1 OF 1				
	REPORT ALL DISCREPANCIES - DO NOT SCALE								